

Date: Thursday, 2/8/2007 12:05:01 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	3" SKID EXTRUSION (NO OUTER RIDGE)
Job Number :	30682		
Estimate Number :	10054		
P.O. Number :	N/A	Part Number :	D26003120
This Issue :	2/8/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2600 REV D1
First Issue :	N/A	Project Number :	N/A
Previous Run :	26205	Drawing Revision :	D1
		Material :	N/A
Written By :		Due Date :	2/28/2007
Checked & Approved By :	<u>07.02.08</u>	Qty:	80
Comment :	Est. D. 02.09.10 Added DSK 066 KJ/RF	Um:	140
		Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3090

07/02/09
 (80)

- a) Extrude as per Dwg D2600
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 120" long
- g) Bon L Canada Inc. tool # 897122
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

2.0	D26003120P	Extrusion Round 3" 350
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 140.0000 Each(s)
 Extrusion Round 3" 350

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

07/02/20 (78) / P

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2600
 Check Pull test per Dwg D2600 for compliance page attached
 Check hardness with Webster tester

07/02/28 (78)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LP Date: 07/03/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID EXTRUSION (NO OUTER RIDGE)

Job Number: 30682

Part Number: D26003120

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Back Hall

JD 7-2-28

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

9 07/03/01

Job Completion



u 07-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DAK</i>	DRAWN BY <i>DAK</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SA</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>+GP</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

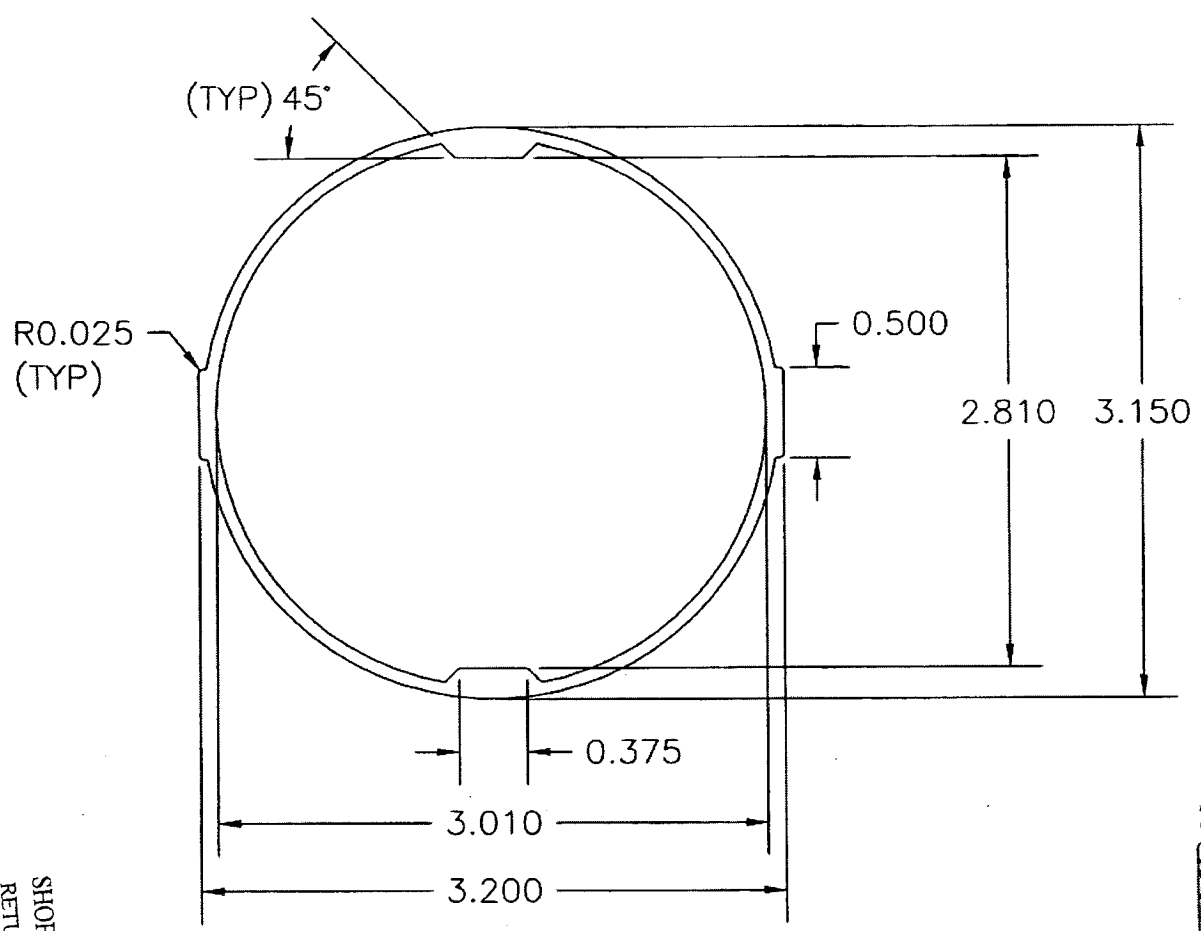
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30682



DESIGN	DRWN BY	DART AEROSPACE LTD	REV. D
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 5
DATE	TITLE	EXTRUSION	SCALE
98.08.20	D2600		1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

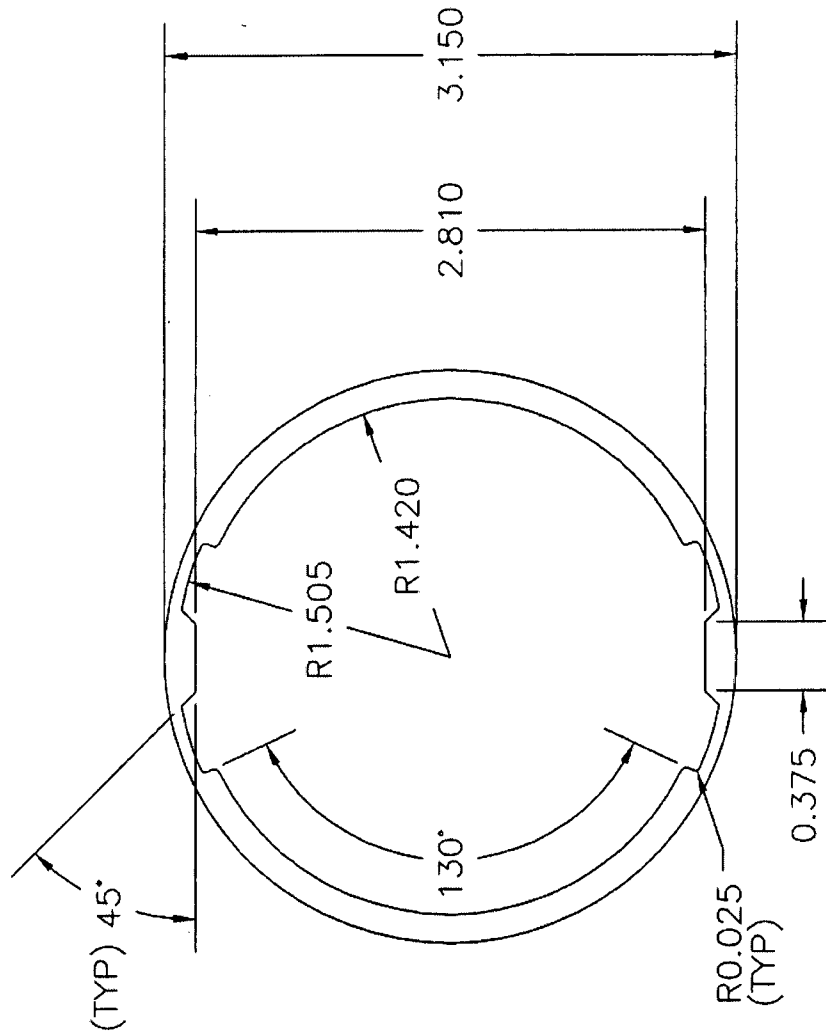


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NO. 30682



DESIGN <i>DAB</i>	DRAWN BY <i>DAB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SA</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

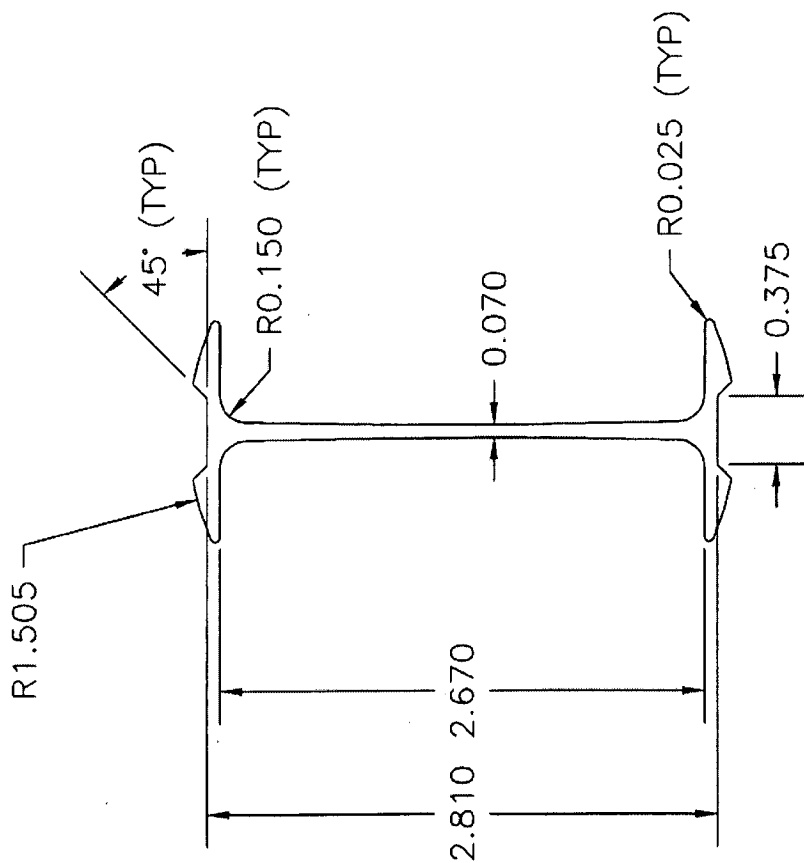
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DESIGN <i>MB</i>	DRAWN BY <i>MB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED
98.8.25. DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

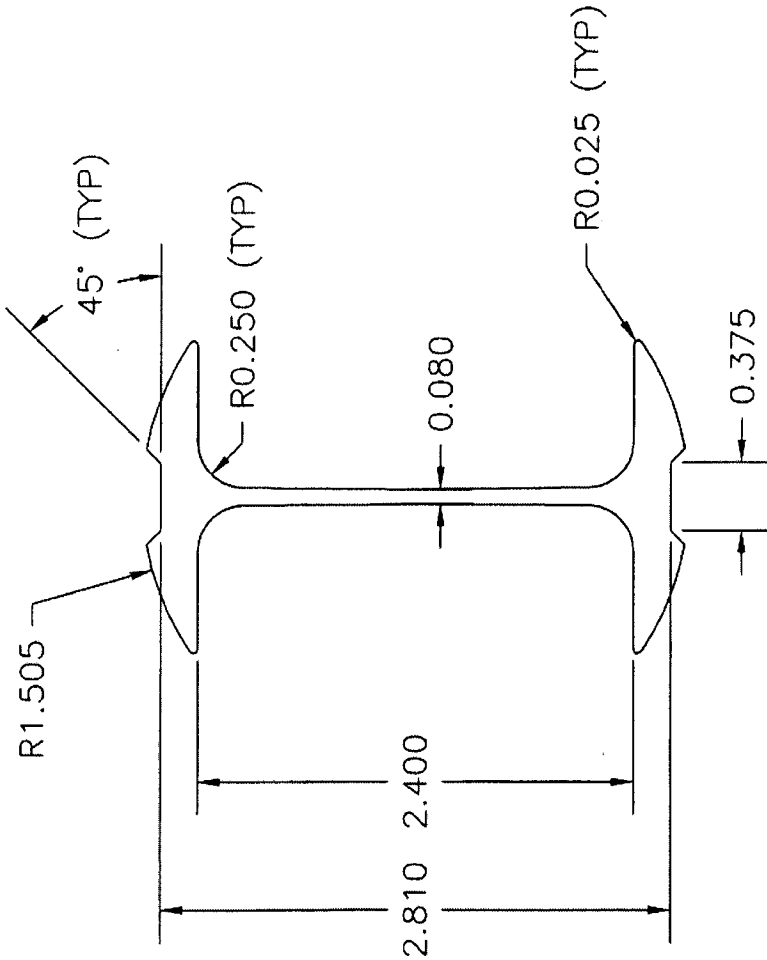


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NO. 30682



DESIGN <i>ME</i>	DRAWN BY <i>ME</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. 0 SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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WORK ORDER
NO. 30682



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert. Date	Cert. No.	Sales Order	Page
02/19/07	155268	58533	1
Cert. No.	Part No.	Lot	Date
00003090	00335009	58533010	2/19/07

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cust. Part
1.000	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Gross Weight	1257 LBS		
Net Qty	1,217 LB 78 PC 780 FT 2 PKG		
Specification	Dis. Desc.		
AMS-QQ-A-200/8 & ASTM B221-00			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	322.8 / 46.9	304.5 / 44.2	12.3	.0	97

Chemical Limits:

	SI	FE	CU	MN	MG	CR	ZN	TI	OTHER
MIN:	.40	.00	.15	.00	.80	.04	.00	.00	EA: .05
MAX:	.80	.70	.40	.15	1.20	.35	.25	.15	TOT: .15

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada

07/02/28
Conchita Ko.